

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001734**Date Inspected:** 10-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** PQR / Plate Material check samples**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

PQR ID#HP2008021

QA Inspector Brannon went to ZPMC staging area for Procedure Qualification Record Test (PQR)

ID#HP2008021 accompanied by ABF Craig Knops. QA Inspector Brannon and ABF Craig Knops noticed that the packaging seal for the KISWEL K-71TSR welding consumable wire Lot #98017 had been damaged. Mr. Knops informed ZPMC personnel that they could not use the above mentioned wire for the PQR test. Mr Knops informed QA Inspector Brannon that the PQR test has been postponed for today.

Plate Material Storage Yard (check samples):

Quality Assurance (QA) Inspector Brannon received plate material list for Caltrans check test samples, plate list received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC plate material storage yard accompanied by ZPMC Quality Control Miss. Zhu Weijuan and Mr. Zhong Chuan. QA Inspector Brannon verified, plate ID #, Grade, Batch # and material test reports. QA Inspector Brannon wrote lot numbers and marked the direction of rolling on each of the 25 samples. Caltrans lot numbers for check samples are as follows.

No. 200 (37th batch) Lot No. B22-031-08, No. 203 (52nd batch) Lot No. B22-029-08, No. 204 (52nd batch) Lot No. B22-039-08, No. 205 (52nd batch) Lot No. B22-042-08, No. 206 (52nd batch) Lot No. B22-053-08, No. 207 (52nd batch) Lot No. B22-041-08, No. 208 (52nd batch) Lot No. B22-044-08, No. 209 (52nd batch) Lot No.

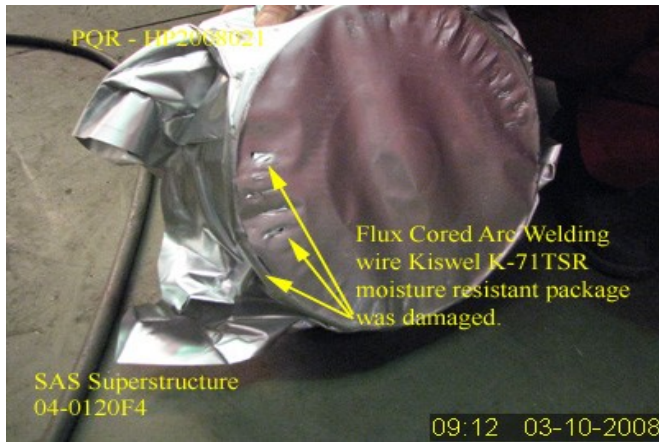
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B22-052-08,

No. 210 (52nd batch) Lot No. B22-047-08, No. 211 (54th batch) Lot No. B22-030-08, No. 212 (55th batch) Lot No. B22-038-08, No. 213 (57th batch) Lot No. B22-040-08, No. 214 (57th batch) Lot No. B22-043-08, No. 215 (57th batch) Lot No. B22-046-08, No. 216 (58th batch) Lot No. B22-035-08, No. 217 (58th batch) Lot No. B22-033-08, No. 218 (58th batch) Lot No. B22-050-08, No. 219 (58th batch) Lot No. B22-034-08, No. 220 (59th batch) Lot No. B22-049-08, No. 221 (59th batch) Lot No. B22-048-08, No. 221 (59th batch) Lot No. B22-036-08, No. 224 (60th batch) Lot No. B22-051-08, No. 225 (52nd batch) Lot No. B22-032-08, No. 226 (65th batch) Lot No. B22-037-08 and No. 227 (66th batch) Lot No. B22-045-08. The above lot numbers were written on the each check sample along with an arrow showing the direction of rolling. The lot numbers, date, batch/heat numbers, plate type/grade and plate thickness were all entered on the Caltrans check sampling tracking log for Caltrans Project 04-0120F4.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

As stated with in the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Brannon,Sherri

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer